

Date: Wednesday, 03/06/2009 10:06:11 AM
User: Melanie Fauteux

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARPLATE
Job Number : 48347	
Estimate Number : 10606	
P.O. Number :	Part Number : D33193 GY
This Issue : 03/06/2009 S.O. No. :	Drawing Number : D3319 REV. B
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SMALL /MED FAB	Drawing Revision : B
Previous Run : 47302	Material :
Written By :	Due Date : 10/06/2009 Qty: 10 Um: Each
Checked & Approved By : <u>MF 09-06-03</u>	
Comment : Est: A 05.05.12 New issue KJJ/JLM Est Rev:B Now on Waterjet 06-10-03 JLM	

Additional Product

Job Number:





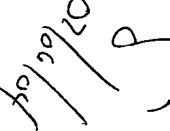


Seq. #:	Machine Or Operation:	Description :
1.0	M1010S18GA	1010/1025 SHEET .048
Comment: Qty.: 3.4150 sf(s)/Unit Total: 34.1502 sf(s) 1010/1025/A21/6aA SHEET .048" Thick Batch: <u>110996</u> <u>B 9-6-3</u>		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D3319 Dwg Rev: <u>B</u> <u>B 9-6-3</u> Prog Rev: <u>B</u> 2-Deburr if necessary <u>B 9-6-3</u>		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>B 9-6-3</u>		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>S 07/06/04</u> <u>(26)</u>		
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
Comment: SMALL & MEDIUM FAB RESOURCE 1 Deburr if necessary <u>N/A</u> <u>S 07/06/04</u>		

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3319-3 PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: S Date: 07/06/15

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR: 48347		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
9/6/03	4 2.0	cut out around Detail G. R.C. water jet malfunction	 QCF 042 09.06.03	SCRAP AND DESTROY NO REPAIR QTY @ NO MAT. LEFT	 9-6-3	 07/06/15	 QCF 042 09.06.03	 07/06/03

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:06:11 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 48347

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

Form using DT8326 & DT8261 as per Dwg D3319 Rev: B

SB 09/06/04

(6)

7.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

S 09/06/04 (X6)

8.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld hard surface using D3319-3T2 per QSI 004 and Dwg D3319 Rev: B

Qty Part Number Description Batch

A/R N/A

7560 Hardcoat Rod

M 109813

EL 9-6-5 (X6)

9.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

09.06.05 (6)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09.06.05 (6)

11.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

START TIME: 11:45am

OVEN TEMPERATURE: 320°C

FINISH TIME: 12:15pm

09.06.08 (X6)

12.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

BK 09-06-8 (6)

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify on inside surface using a permanent fine point marker with the following:

TCCA-PDA, Dart Aerospace Ltd.

497
9469 20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/06/2009 10:06:11 AM
User: Melanie Fauteux

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPLATE

Job Number: 48347

Part Number: D33193

Job Number:



Seq. #:

Machine Or Operation:

Description :

P/N: D3319-3, B/N: BXXXXX

For Product Eligibility see PDA05-18

and Stock

Location: _____

51. 497

mf 09-06-09

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/09 mf

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf 09-06-09

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	48347
Description: Wearplate		Part Number:	D3319-3
Inspection Dwg: D3319 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
75.52	+/-0.030	75.52	*			
74.420	+/-0.010	74.420	*			
62.770	+/-0.010	62.770	*			
52.890	+/-0.010	52.890	*			
30.790	+/-0.010	30.790	*			
8.690	+/-0.010	8.688	*			
0.60	+/-0.030	.599	*			
2.690	+/-0.010	2.698	*			
2.940	+/-0.010	2.949	*			
3.527	+/-0.010	3.526	*			
4.518	+/-0.010	4.519	*			
Ø0.190	+0.005/-0.001	.192	*			
2.940	+/-0.010	2.943	*			
2.940	+/-0.010	2.948	*			
2.690	+/-0.010	2.698	*			
5.063	+/-0.010	5.061	*			
6.163	+/-0.010	6.165	*			
Ø0.316 x 0.607	+0.006/-0.001 x +/-0.010	.317 x .608	*			
0.048	+/-0.010	.048	*			

Measured by:	B	Audited by:	S	Prototype Approval:	N/A
Date:	9-6-3	Date:	9/6/04	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.07.18	New Issue	KJ/JLM	BE

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

HAWKESBURY, ONTARIO, CANADA

REV. 8/10

REV. 8/10

10

555

SHEET 1 OF 5

05.06.06

WEARPLATE

1:8

A

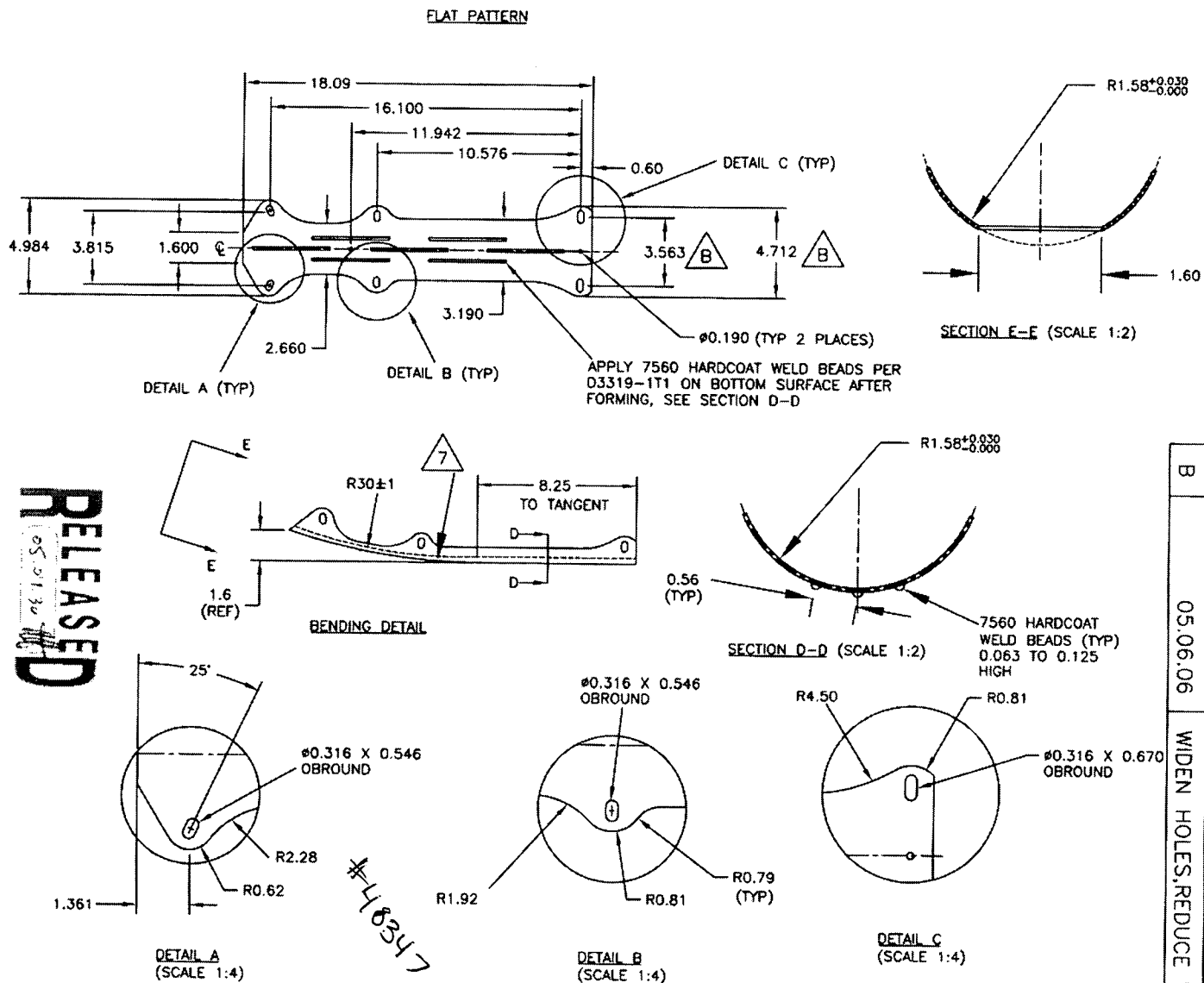
04.09.24

NEW ISSUE

B

05.06.06

WIDEN HOLES,REDUCE WIDTH -3/-5/-7



D3319-1 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

RELEASED
2025-01-30

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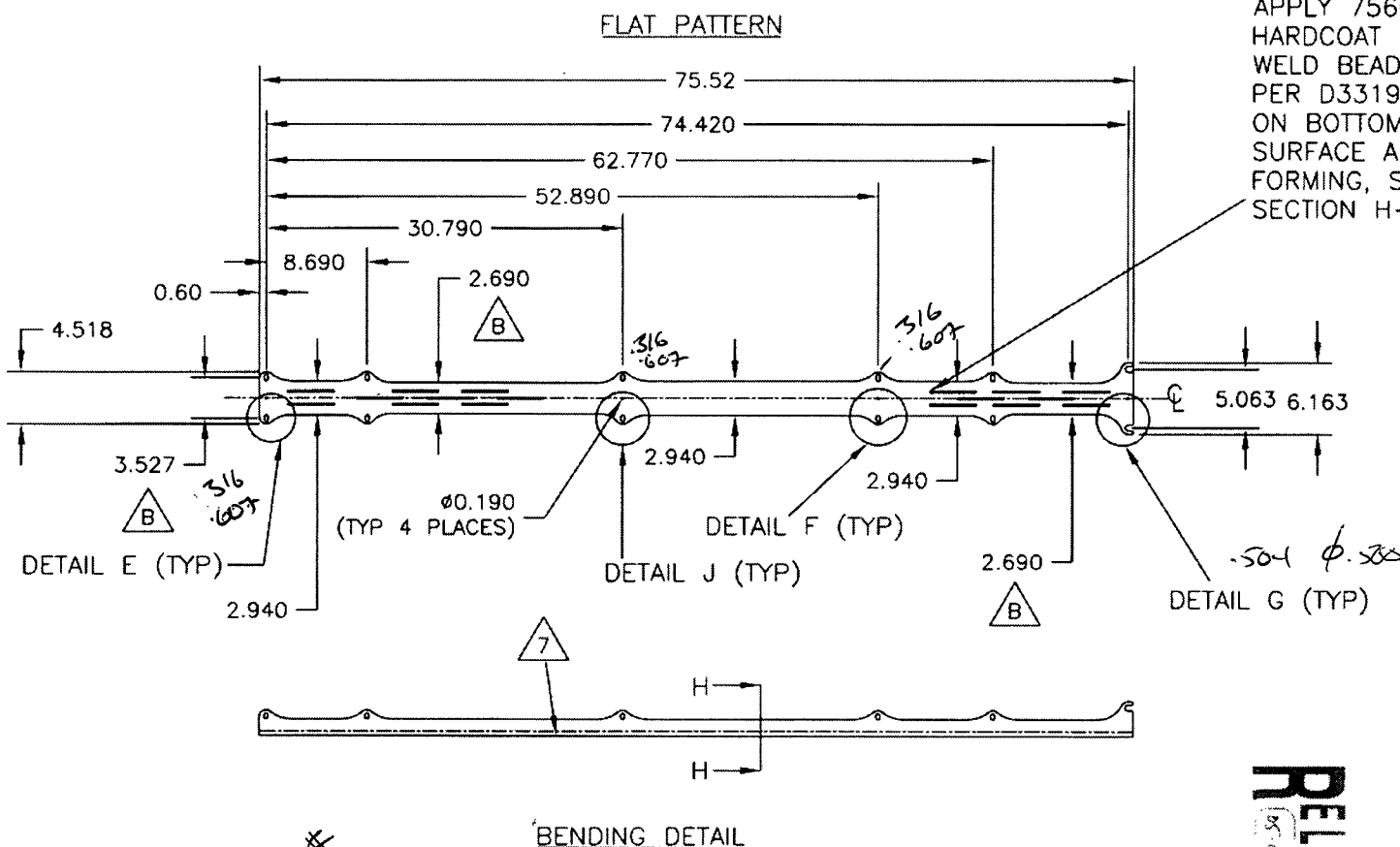
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DART

DESIGN	05.06.06	DRAWN BY	DART AEROSPACE LTD
CHECKED		APPROVED	HAWKESBURY, ONTARIO, CANADA
DATE		TITLE	WEARPLATE
		DRAWING NO.	D3319
		SHEET 2 OF 5	
		SCALE	1:15

APPLY 7560
HARDCOAT
WELD BEADS
PER D3319-3T1
ON BOTTOM
SURFACE AFTER
FORMING, SEE
SECTION H-H



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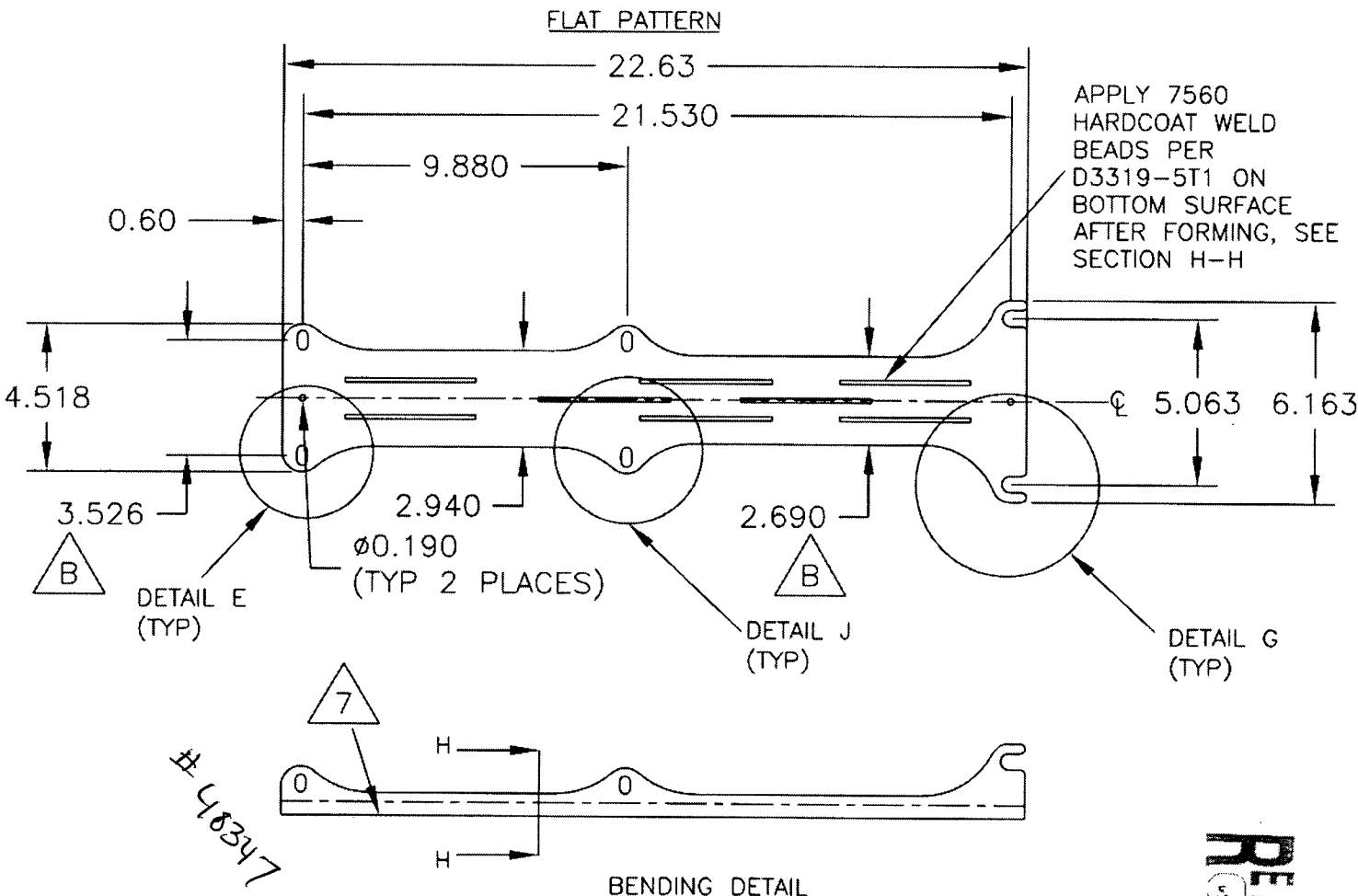
D3319-3 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-3 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

DART

DESIGN	D41	DRAWN BY	GH	DART AEROSPACE LTD
CHECKED	GH	APPROVED	GH	HAWKESBURY, ONTARIO, CANADA
DATE	05.06.06	DRAWING NO.	D3319	REV. B
		TITLE	WEARPLATE	SHEET 3 OF 5
				SCALE 1:5

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05-07-30-11

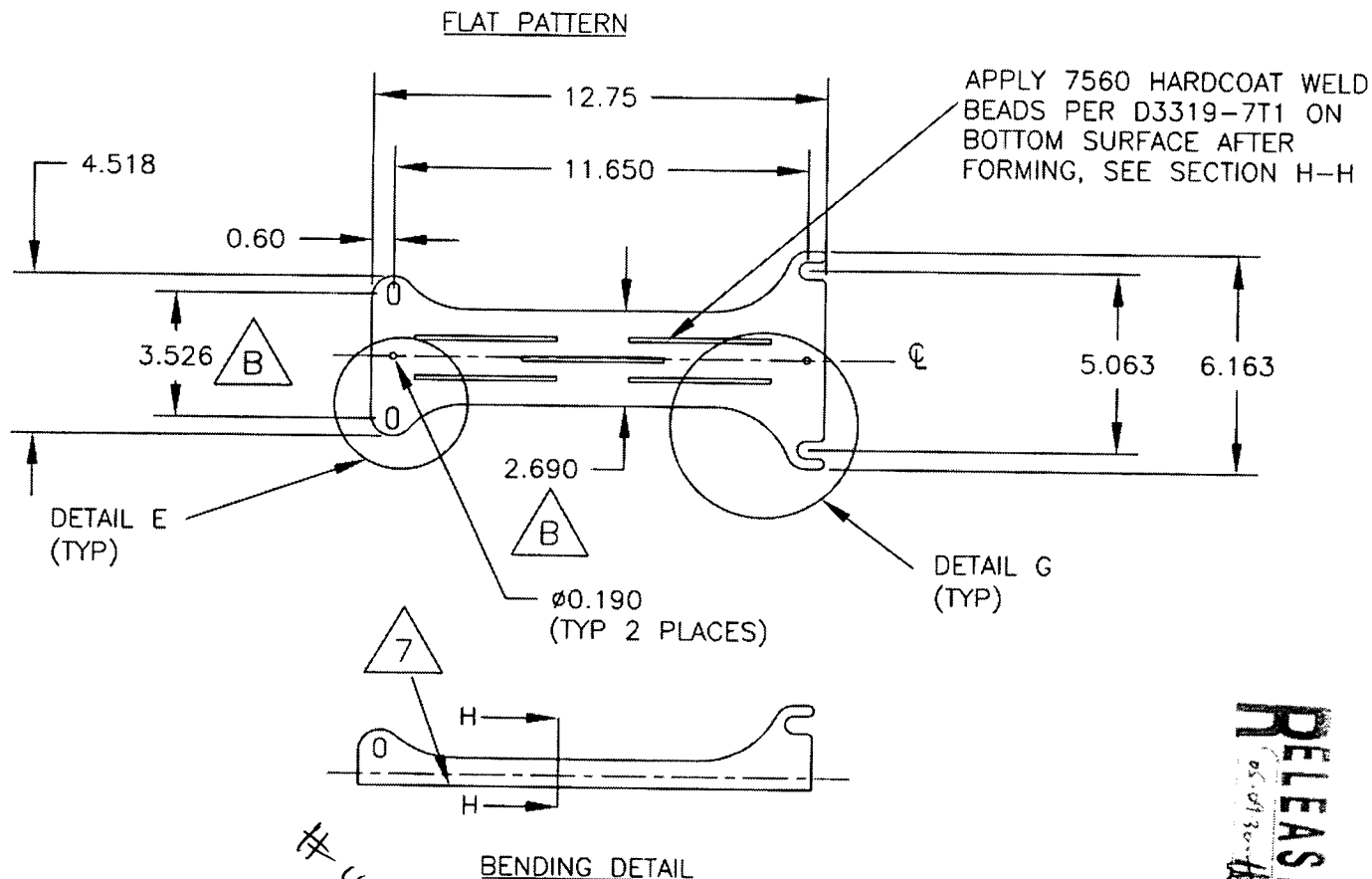


D3319-5 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
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FOR PRODUCT ELIGIBILITY SEE PDA05-18"

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CHECKED [Signature]	APPROVED [Signature]	D3319	SHEET 4 OF 5	
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:5	

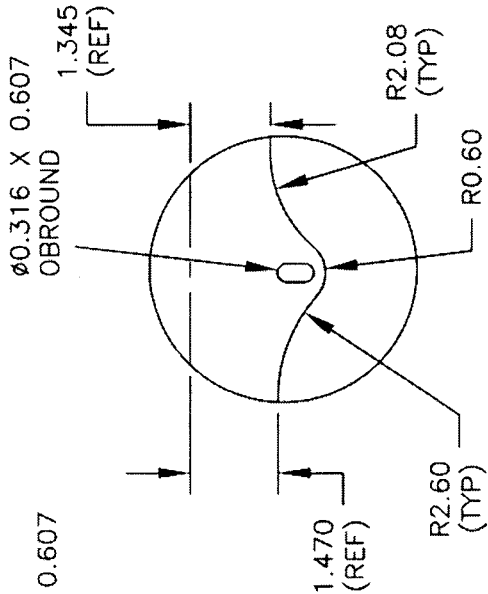
RELEASED
05.01.30.11D3319-7 WEARPLATE

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
- 2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) PART IS SYMMETRICAL ABOUT CENTERLINE
- 5) ALL DIMENSIONS IN INCHES
- 6) WELD PER DART QSI 004
- 7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-7 B/N BXXXXX,
FOR PRODUCT ELIGIBILITY SEE PDA05-18"

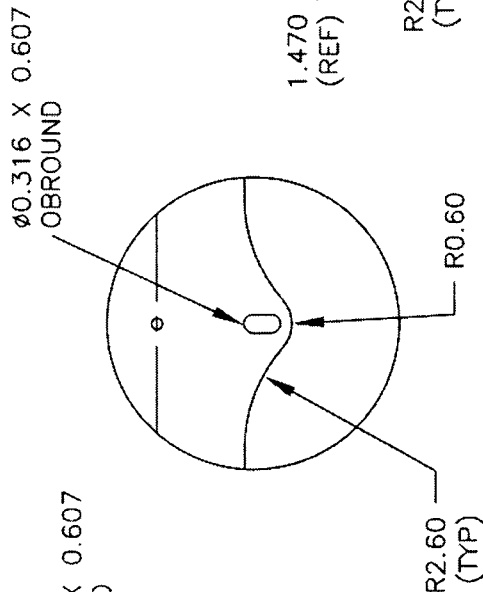


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CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3319	REV. B SHEET 5 OF 5
DATE 05.06.06		TITLE WEARPLATE	SCALE 1:3

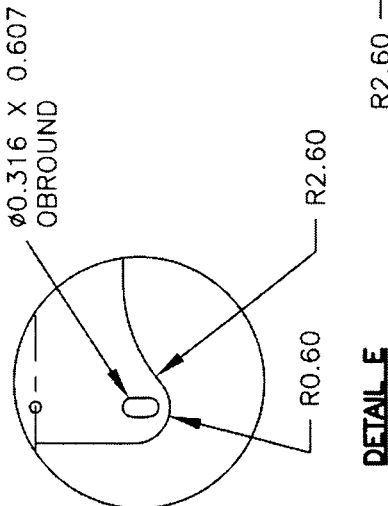
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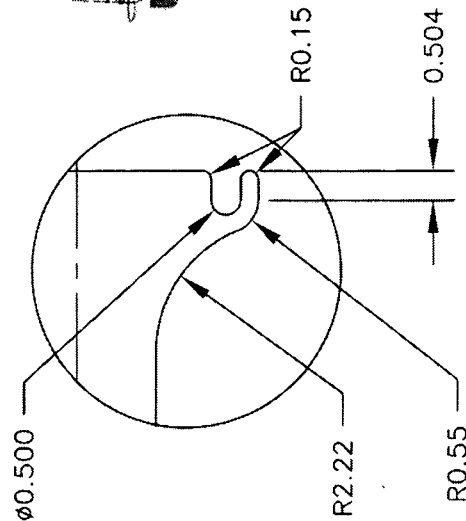
DETAIL J



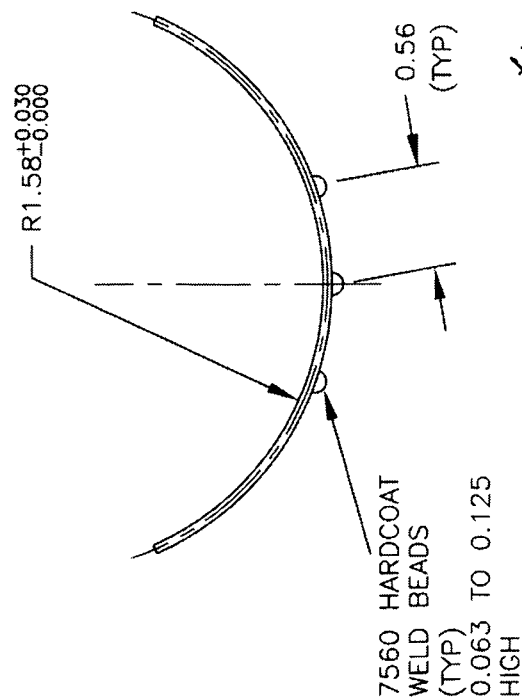
DETAIL F



DETAIL E



DETAIL G



SECTION H-H
(SCALE 1:1)

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